



Dart Aerospace Ltd.
1270 Aberdeen St
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D350-591-213
Job Sheet 180682-A



Split

Part No: D350-591-213

Job Qty: 1 ea

Part Name: Heli-Access-Step™ LH - High Gear, Short Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/22/18

Job Tracking No:

Due Date: 8/3/18

Created By: Sonia Quirion

Type: SOLD

Description:

Note: DWG REV H IPP Rev:B 05.10.14 Modified step 10 KJ/EC IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLMIPP REV:D 14.12.17 ADD DSI9712-011 DD VERF:JLM IPP Rev:C 06-06-27 Revised as per DSI9340 JLM IPP Rev:D 10.03.17 incorporate seq 180 to 200 remove qc5 DD verified by:JLM IPP Rev:E 10.11.15 update qty on AN4-11A DD verf:EC IPP REV:F 16.03.16 IIN REV:H DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/25/18	8/3/18	0.00	0.00	Start Up Stores/Pkg-2		SEP 20 2018
270	Packaging	1 pcs		8/3/18	0.00	0.00	Packaging1-3		SEP 20 2018
280	QC	1 pcs		8/3/18	0.00	0.00	QC4		SEP 20 2018
290	Packaging	1 pcs		8/3/18	0.00	0.00	Packaging3-1		SEP 20 2018
295	DC	1 pcs		8/3/18	0.00	0.00	DC		SEP 20 2018
300	QC21-FG	1 Ea		8/3/18	0.00	0.00	QC21		SEP 20 2018

Part Op 290 - Identify and pack for shipping as per PPP D350-591-213
Descriptions: 295 - Photocopy bluefile and type labels as per PPP D350-591-213 CHG005

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-35A	Bolt	2 Ea (2 ea)	90-Start up Operation	5067891
AN4-15A	Bolt <i>5091916 x 2</i>	4 Ea (4 ea)	90-Start up Operation	5057424 x 2
AN5-36A	Bolt	2 Ea (2 ea)	90-Start up Operation	5071345
D2618	Bushing	2 Ea (2 ea)	90-Start up Operation	5082275
D2732-030	Rubber Cushion - 3"	4 Ea (4 ea)	90-Start up Operation	5053726
D3235-1	Mounting Lug	2 Ea (2 ea)	90-Start up Operation	5089615
D3338-1	Mounting Lug	1 Ea (1 ea)	90-Start up Operation	5080379
MS21042L3	Nut	2 Ea (2 ea)	90-Start up Operation	5078167
MS21042L4	Nut	6 Ea (6 ea)	90-Start up Operation	5089365
MS21042L5	Nut	2 Ea (2 ea)	90-Start up Operation	5059178
NAS1149D0363J	Washer	4 Ea (4 ea)	90-Start up Operation	5068661
NAS1149D0463J	Washer	12 Ea (12 ea)	90-Start up Operation	5071558
NAS1149D0563J	Washer	4 Ea (4 ea)	90-Start up Operation	5068662
D2230-3	Mounting Lug	2 Ea (2 ea)	270-Packaging	5103723
D3078-041	Step Assembly, Hi Short LH	1 Ea (1 ea)	270-Packaging	5007967



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Container No: **S104148**



Heli - Access - Step LH - High Gear, Short Step, Aerazur
Float Compatible

PART NO: **D350 - 591 - 213**

Serial No/Batch: **S096370**

Revision:

Operation:

Change No:

Packaging
CHG005

Mfr Date: 08/22/18

JOB No: 180682 - A

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-35A	2	531	0
	AN4-15A	4	273	0
	AN5-36A	2	474	0
	D2618	2	355	0
	D2732-030	4	187	0
	D3235-1	2	126	0
	D3338-1	1	26	0
	MS21042L3	2	3,922	0
	MS21042L4	6	5,582	0
	MS21042L5	2	1,066	0
	NAS1149D0363J	4	1,835	0
	NAS1149D0463J	12	9,537	0
	NAS1149D0563J	4	2,052	0
	D2230-3	2	81	0
270-Packaging	D3078-041	1	3	0
Part Specifications				
Specifications could not be found.				

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D350-591-213
Job Sheet 180682



Part No: D350-591-213

Job Qty: 4 ea

Part Name: Heli-Access-Step™ LH - High Gear, Short Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/12/18

Job Tracking No:

Due Date: 8/3/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV H IPP Rev:B 05.10.14 Modified step 10 KJ/EC IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLMIPP REV:D 14.12.17 ADD DSI9712-011 DD VERF:JLM IPP Rev:C 06-06-27 Revised as per DSI9340 JLM IPP Rev:D 10.03.17 incorporate seq 180 to 200 remove qc5 DD verified by:JLM IPP Rev:E 10.11.15 update qty on AN4-11A DD verf:EC IPP REV:F 16.03.16 IIN REV:H DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		8/3/18	0.00	0.00	Start Up Stores/Pkg-2		JUL 25 2018
270	Packaging	4 pcs		8/3/18	0.00	0.00	Packaging1-3		
280	QC	4 pcs		8/3/18	0.00	0.00	QC4		
290	Packaging	4 pcs		8/3/18	0.00	0.00	Packaging3-1		
295	DC	4 pcs		8/3/18	0.00	0.00	DC		
300	QC21-FG	4 Ea		8/3/18	0.00	0.00	QC21		

Part Op 290 - Identify and pack for shipping as per PPP D350-591-213
Descriptions: 295 - Photocopy bluefile and type labels as per PPP D350-591-213 CHG005

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-35A	Bolt	8 Ea (2 ea)	90-Start up Operation	50674624X2
AN4-15A	Bolt	16 Ea (4 ea)	90-Start up Operation	5071301
AN5-36A	Bolt	8 Ea (2 ea)	90-Start up Operation	5071301
D2230-3	Mounting Lug	8 Ea (2 ea)	90-Start up Operation	5071301
D2618	Bushing	8 Ea (2 ea)	90-Start up Operation	5071301
D2732-030	Rubber Cushion - 3"	16 Ea (4 ea)	90-Start up Operation	5071301
D3235-1	Mounting Lug	8 Ea (2 ea)	90-Start up Operation	5071301
D3338-1	Mounting Lug	4 Ea (1 ea)	90-Start up Operation	5071301
MS21042L3	Nut	8 Ea (2 ea)	90-Start up Operation	5071301
MS21042L4	Nut	24 Ea (6 ea)	90-Start up Operation	5071301
MS21042L5	Nut	8 Ea (2 ea)	90-Start up Operation	5071301
NAS1149D0363J	Washer	16 Ea (4 ea)	90-Start up Operation	5071301
NAS1149D0463J	Washer	48 Ea (12 ea)	90-Start up Operation	5071301
NAS1149D0563J	Washer	16 Ea (4 ea)	90-Start up Operation	5071301
D3078-041	Step Assembly, Hi Short LH	4 Ea (1 ea)	270-Packaging	5071301

5167967

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-35A	8	380	0
	AN4-15A	16	445	0
	AN5-36A	8	324	0
	D2230-3	8	247	0
	D2618	8	511	0
	D2732-030	16	71	0
	D3235-1	8	273	0
	D3338-1	4	19	0
	MS21042L3	8	1,920	0
	MS21042L4	24	3,914	0
	MS21042L5	8	870	0
	NAS1149D0363J	16	1,444	0
	NAS1149D0463J	48	7,036	0
	NAS1149D0563J	16	1,587	0
	D3078-041	4	0	0
Part Specifications				
Specifications could not be found.				

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PAGE 1 OF 1

Description: HELI-ACCESS STEP, HIGH SKID, SHORT STEP, LH/RH

H:\Forms\Engineer\Approved Eng Online\CHGREC revB

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Hel-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Hel-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Hel-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Hel-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Hel-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Hel-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

REFERENCE ONLY

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 REV. 3
REF TCCA STC: SH92-6
REF FAA STC: SH967NE

1.0 Purpose

It has come to DART's attention that it may be difficult to fasten the D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Step Installations to the forward crosstube due to variations between crosstubes. For this reason, DART is adding the D3338-1 Mounting Lug to the D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Step Kits at CHG 004 and later.

For D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Step Kits at CHG 003 and earlier, DSI 9712-011 Mounting Lug Kit can be procured from DART. The kit contains all parts to upgrade a single step kit.

2.0 Installation

- 2.1 It is acceptable to install the D3338-1 Mounting Lug in lieu of the D2230-1 Mounting Lug as required to reduce the gap between step and the forward crosstube in accordance with the figures of this service instruction.
- 2.2 The height to set up the D350-591-133 Maintenance Step has been revised from 7.0in to 6.0in $\pm$ 1.0in to provide more flexibility. See sheet 2 of this service instruction.
- 2.3 In all other respects, install the D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Steps in accordance with Section 3.1 of Installation Instructions D350-591 or Section 32.1 of Instructions for Continued Airworthiness ICA-D350-591.

3.0 Parts List Change

The following additional part is provided with D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Steps at CHG 004:

Qty -133	Qty -213	Qty -214	Part Number	Description
X			D350-591-133	Heli-Access-Step™, Aft Maintenance Step
	X		D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
		X	D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
1	1	1	D3338-1	MOUNTING LUG (ADD)

4.0 DSI 9712-011 Mounting Lug Kit Parts List

For existing D350-591-133 Aft Maintenance Steps and D350-591-213/-214 Heli-Access-Steps at CHG 003 or earlier, one DSI 9712-011 kit upgrades one step installation:

Qty -011	Part Number	Description
X	DSI 9712-011	Mounting Lug Kit
1	D3338-1	MOUNTING LUG

REFERENCE ONLY

5.0 Weight and Balance

There is a negligible weight change associated with this modification.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.12.04
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE	MB	14.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9712	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		INSTALLATION OPTION	NTS
DATE	14.10.22	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	